



Date: Wednesday, 04/10/2006 2:21:07 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 28856	
Estimate Number : 10608	
P.O. Number : <i>NIA</i>	Part Number : D2655
This Issue : 04/10/2006 S.O. No. : <i>NIA</i>	Drawing Number : D2655 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 28856	Material : <i>NIA</i>
Written By : 	Due Date : 25/10/2006
Checked & Approved By : 	Qty: <i>11</i> Um: Each
Comment : Est. D 00.06.22 Removed P/O for powder coat EC Est Rev:E Now on Waterjet 06-10-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1018B400X250	Inventory
-----	---------------	-----------



Comment: Qty.: 0.2835 f(s)/Unit Total : 5.6700 f(s)
 1018 ASTM A36 .250" thk bar x 4.0"
 Batch: *m16210 ml 06 10 05*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2655
 Dwg Rev: *B*
 Prog Rev: *B*

*ml 06 10 05**(11)*

2-Deburr if necessary

ml 06 10 05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 06 10 05**(11)*

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*JCB 10-10 (11)*

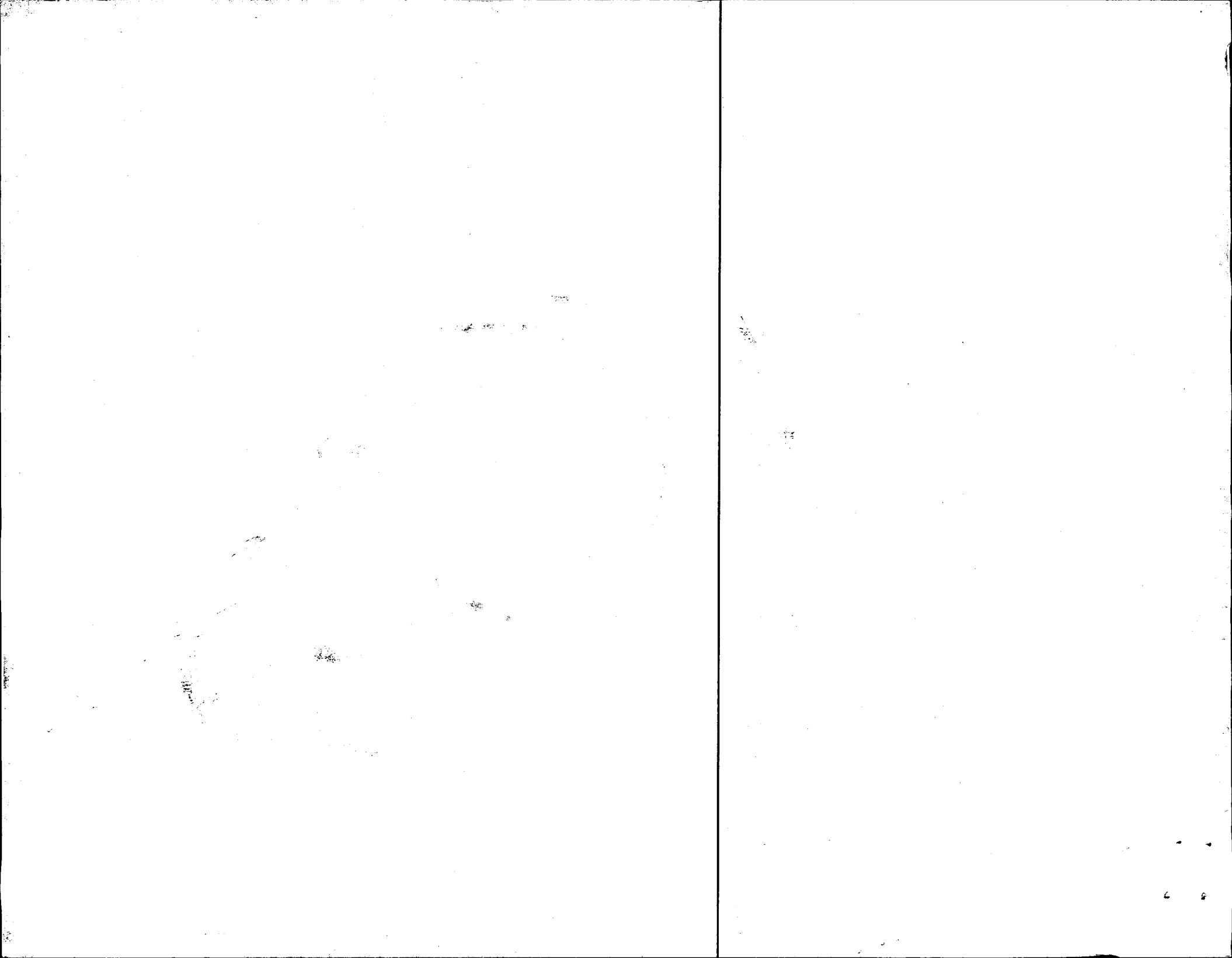
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

*ml 06 10 10**(11)*



Date: Wednesday, 04/10/2006 2:21:07 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28856

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-10 (14)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

a.m 06/10/11 (14)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/12 11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST140*

06/10/12 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/12 (11)

Job Completion



Job 10-12

Date: Tuesday, 10/3/2006 3:47:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 28856		
Estimate Number	: 10608		
P.O. Number	:	Part Number	: D2655
This Issue	: 10/3/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2655 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 27110	Drawing Revision	: B
	Type : PURCHASED PARTS	Material	:
Written By	:	Due Date	: 10/28/2006
Checked & Approved By	:	Qty:	20
Comment	: Est. D 06.06.22 Removed P/O for powder coat EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Laser Cut per D2655

Material release note required

*250x4" 1018
 .270 F22*

W/Target

2.0

D2655F

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Ring

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28856

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat per QSI 005 4.3.5.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

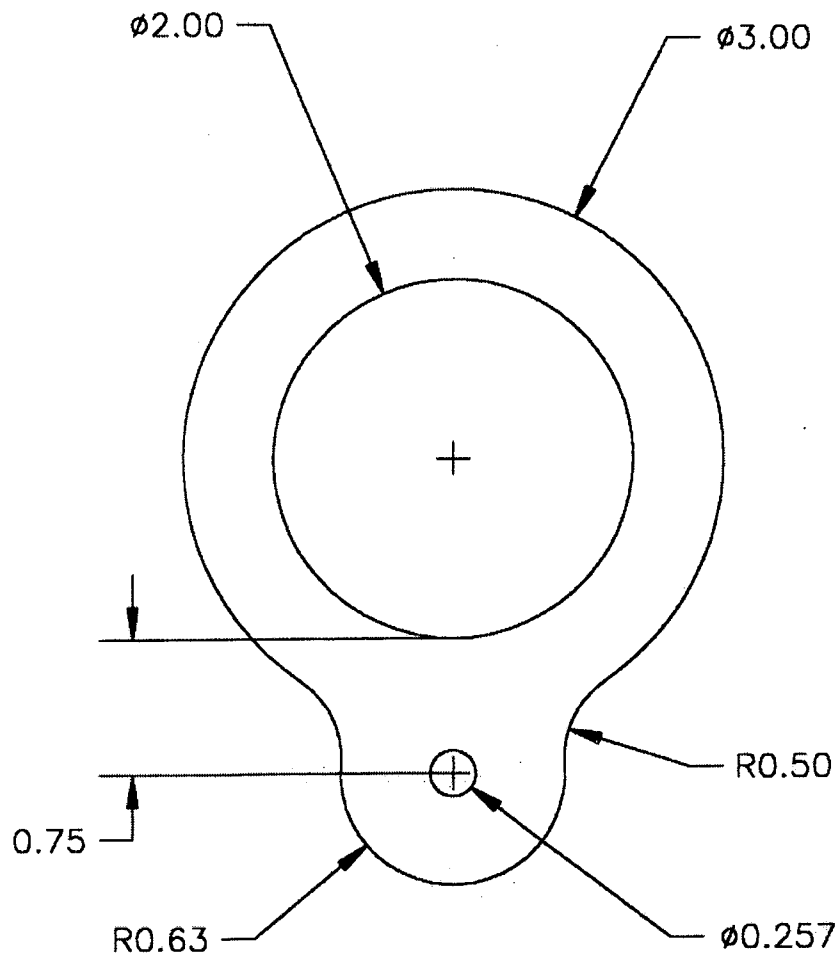
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47 07 14 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28856

NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

